

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY		
Job Number	: 26894				
Estimate Number	: 10699				
P.O. Number	: N/A	Part Number	: D3391025		
This Issue	: 5/1/2006	S.O. No.	: N/A	Drawing Number	: D3391 REV D
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: N/A	Type	: LANDING GEAR	Drawing Revision	: D
Previous Run	: 26893			Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 5/20/2006	Qty:	1
Checked & Approved By	: <u>W</u>			Um:	Each
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC				
	: Est Rev:C 06-03-28 Update Manufacturing Instructions JLM				

Job Number:

Page 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 8:42:09 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26894

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 06/05/10

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

EP 06/05/10

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DP 06-5-25

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 06-5-25

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

> DP 06-5-25

DP 06-5-26

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 06-05-29

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BS 06-05-29

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Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/05 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 06/05/1

14.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

14 AESS10KB366 Insert

M17905

15.0

NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

8 NAS1330C3KB166 Insert

M100732

16.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

2 AESS10KB266 Insert

M17905

or NAS1330C3KB266 ✓

17.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty Part Number Description Batch

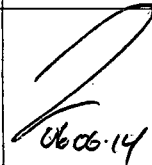
2 AESS10KB316 Insert

M17905

or NAS1330C3KB316

DL 06/06/05 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/06/10	17.1	Add step to install inserts	DL	06/06/10			 06/06/14	
	17.2	Add Step QCS to inspect inserts - Jan 06/14 for QCS						
06/06/10	22.0	Remove, install inserts	DL	06/06/10				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26894

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number Description Batch

1

D2646

B25381

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description Batch

2

AN3C4A

M100651

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Inventory

Pick:

Qty

Part Number

Description Batch

2

AN960C10L

M18822

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description Batch

2

NAS1515H3L

M100186

DU 06/06/05

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg 2-91

DU 06/06/05

①

2-Install Aft Cap as per Dwg 2-91

A/R Sikaflex-241/291

Sikaflex expiry date:

M0126
11/06

DU 06/06/05

④

J

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Prod eng Qty	Approval Chief Eng Pending	Approval QC Inspector
060608	18.0 19.0 20.0 21.0	Should be put on Float Skid Assembly W/O N/A 26/06/08	FC	06 06 08			060614

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MM *01 of 05* (1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *N/A*

DC *06/06/12* (1)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

12 *06/06/14* (1)

Job Completion



U *06/06/12*

Dart Aerospace Ltd

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26894
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.494	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	45.000	—			
3.200	+/-0.010	3.200	✓			
1.526	+0.000/-0.030	1.520	—			
0.200	+/-0.010	0.195	—			
7.500	+/-0.010	7.496	—			
27.750	+/-0.010	27.750	—			
31.750	+/-0.010	31.750	—			
35.250	+/-0.010	35.250	—			
0.400	+/-0.010	0.393	—			
00.208	+0.005/-0.001					
3.300	+/-0.010	3.294	—			
0.200	+/-0.010	0.197	—			
3.520	+/-0.010	3.528	✓			
0.687	+0.010/-0.000	0.688	✓			
R0.062	+/-0.010	R0.062	—			
Ø0.484	+0.005/-0.001	R0.486	—			

Measured by: MS / JMK	Audited by: En	Prototype Approval:	N/A
Date: 06/05/10	Date: 06/05/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue	KJ/JLM	

